



Date: Wednesday, 9/13/2006 4:29:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR INLET ADAPTER
Job Number : 28518	
Estimate Number : 12247	
P.O. Number : N/A	Part Number : D3477041
This Issue : 9/13/2006 S.O. No. : N/A	Drawing Number : D3477 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26597	Material : N/A
Written By : 	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By :  06/09/14	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D34773	Tube
-----	--------	------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-3	Tube	B 28751

2.0	D34771	Flange
-----	--------	--------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-1	Flange	B 28564

3.0	D34775	BLOWER ADAPTER FLANGE
-----	--------	-----------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-5	Flange	B 28568

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

-m.F. 06/10/03. (4)

m.F. 06/10/03 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *D* Date: 06/18/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR INLET ADAPTER

Job Number: 28518

Part Number: D3477041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

SB 06/10/03

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

57950

06/10/04

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/04

(4)

Job Completion



C 2006/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

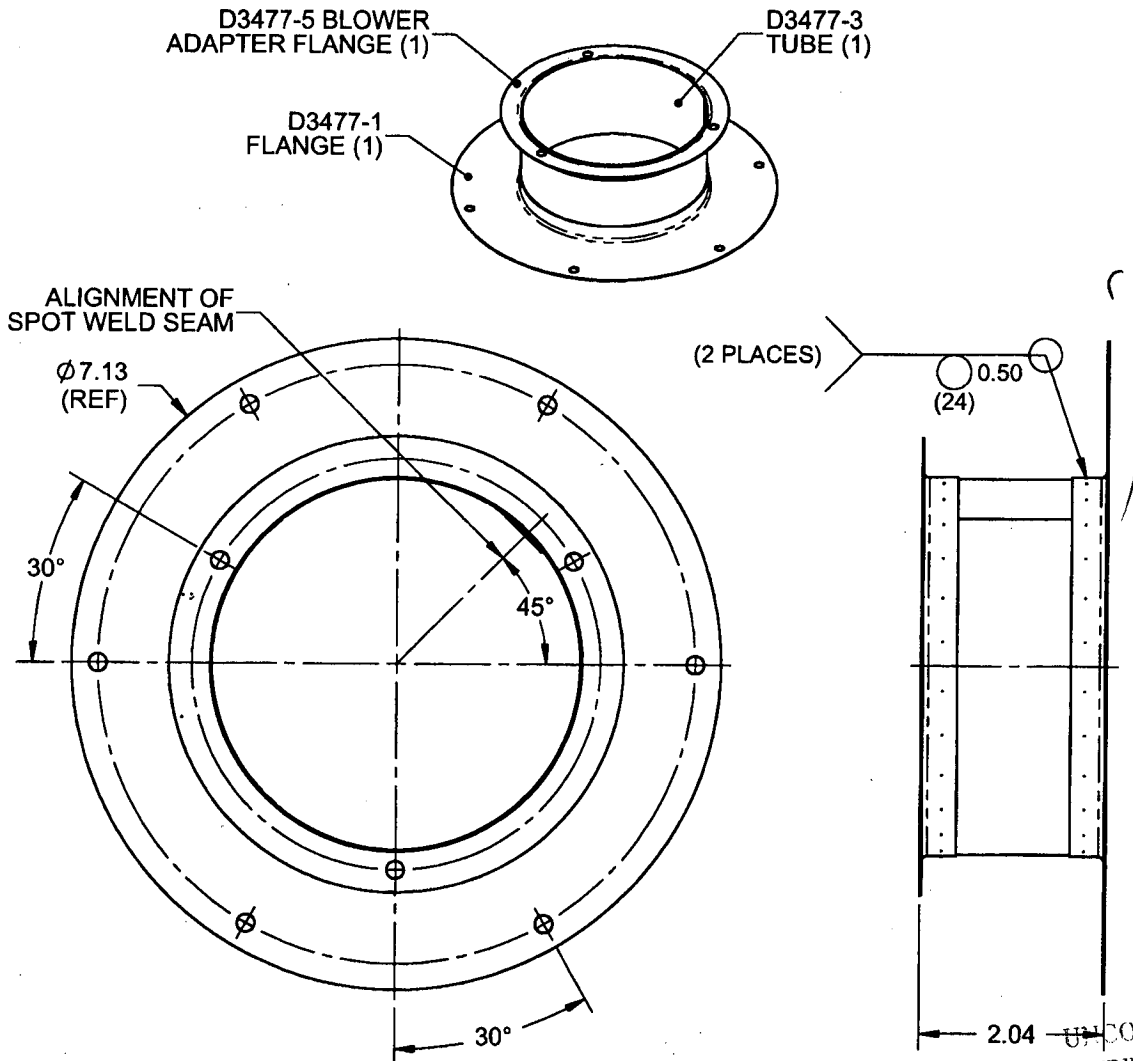
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3477	REV. A SHEET 1 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	

**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

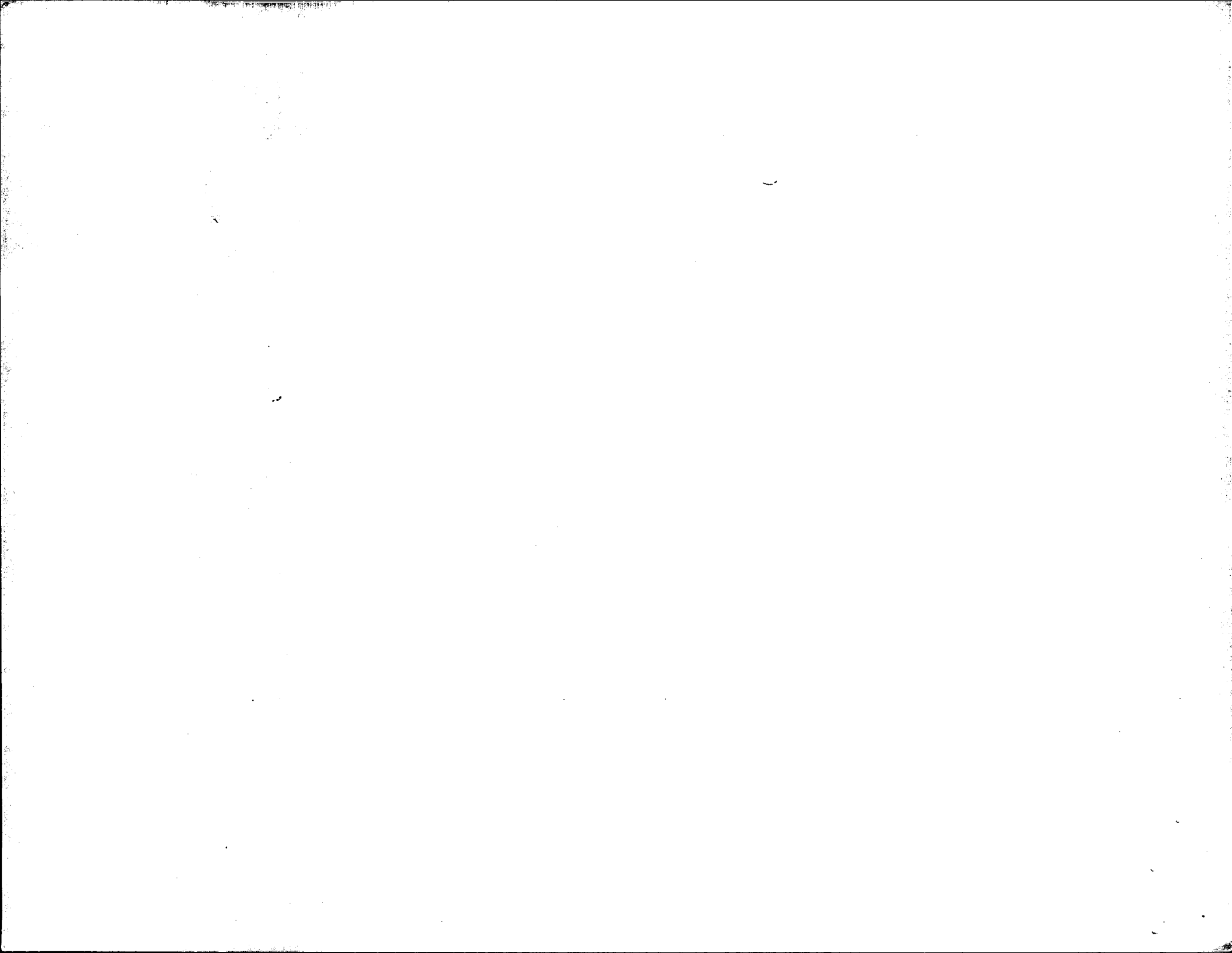
QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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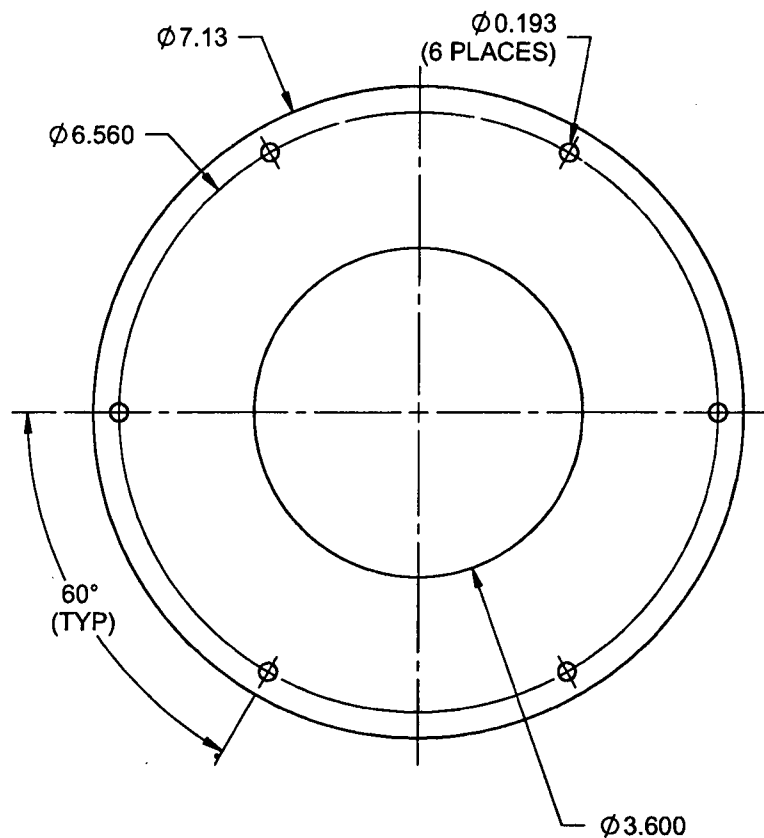
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WORK ORDER
NO. **28518**

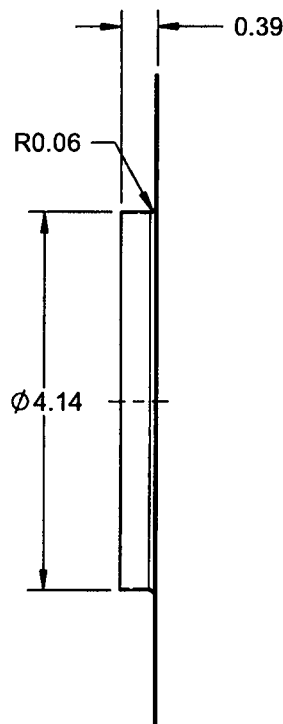




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 2 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2



**D3477-1F FLANGE
FLAT PATTERN**



**D3477-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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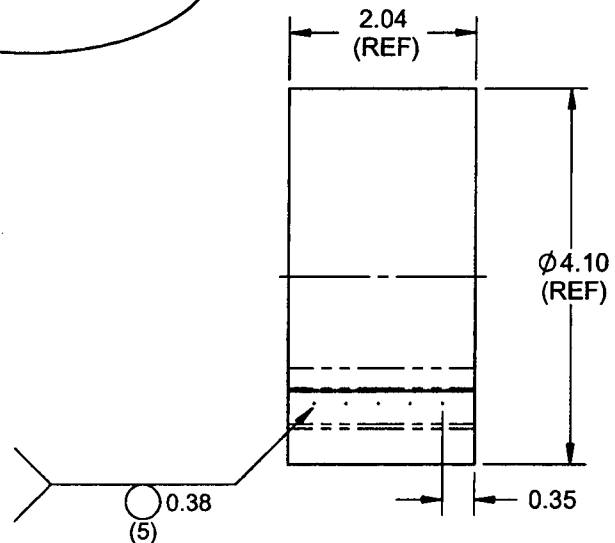
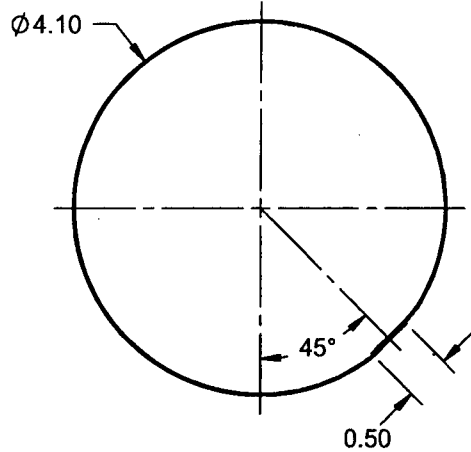
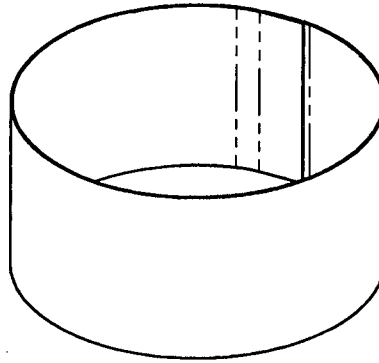
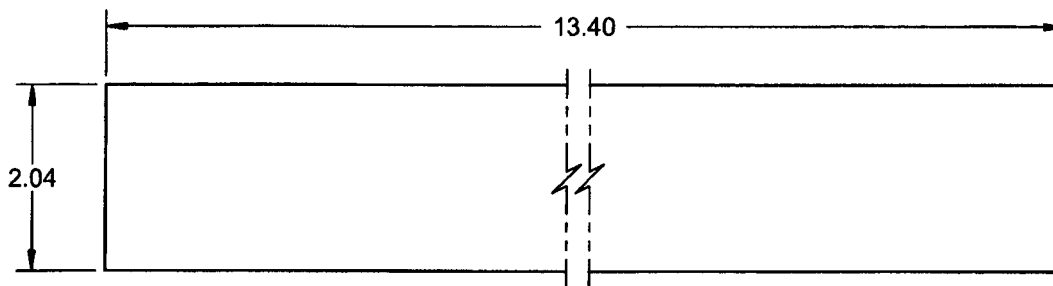
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CHECKED #1	APPROVED #1	DRAWING NO. D3477	REV. A SHEET 3 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

#1 06.04.03

**D3477-3 TUBE****D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

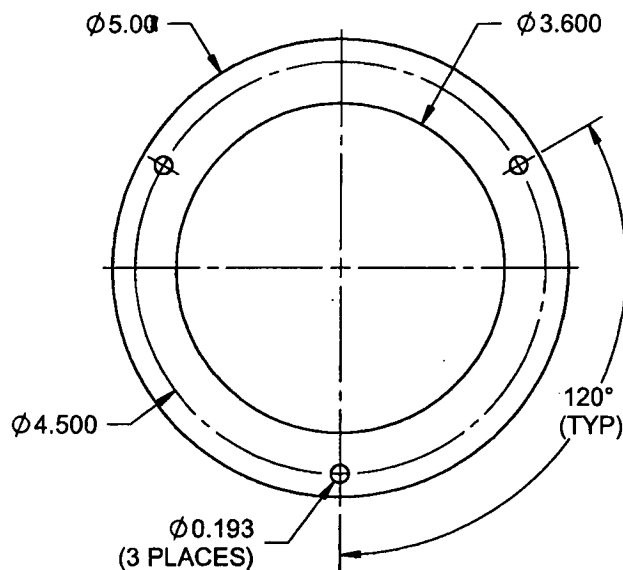
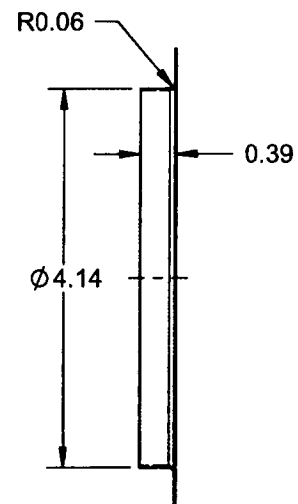
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 4 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

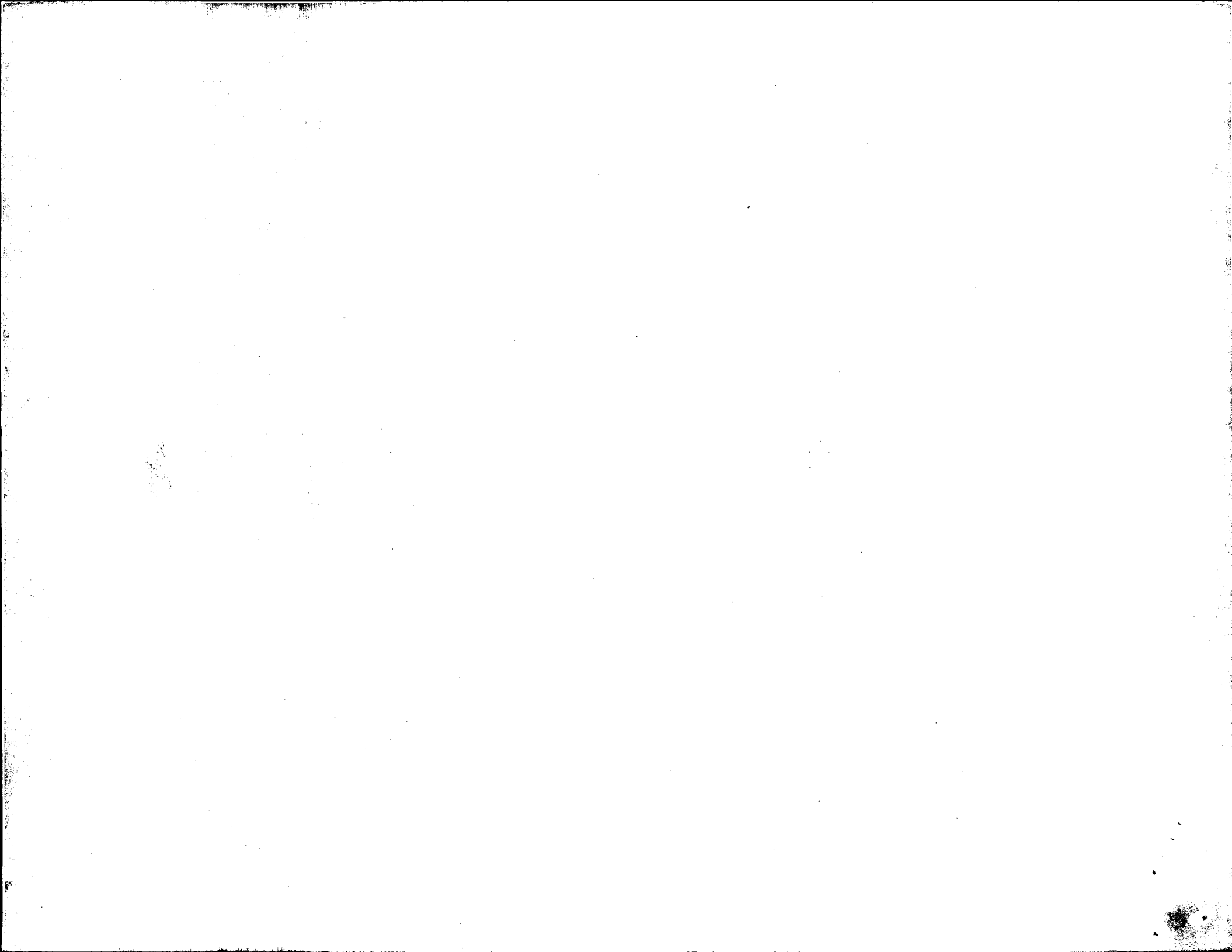
06.04.03**D3477-5F FLAT PATTERN****D3477-5 BLOWER
ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 23

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Fauteux
Joint Welding Procedure Spot Welding
Part number and Job number 53477-041 B 28518

TEST WELDS REQUIRED

BASE METAL 304 2G WELDING PROCESS Spot
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒ N/A
Position Vertical Down ☐ Up ☐
Sheet Groove 1G ☐ 2G ☐ 3G ☐ 4G ☐
Tube Groove 1G ☐ 2G ☐ 5G ☐ 6G ☐
Sheet Fillet 1F ☐ 2F ☐ 3F ☐ 4F ☐ N/A
Tube Fillet 1F ☐ 2F ☐ 4F ☐ 5F ☐
Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/03 Qualifier Sylvie Pouchet

